



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4702

Job Sheet 176644



003837

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 6/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/7/18	0.00	0.00	Start Up Stores/Pkg-1		18-06-12
110	Small Fab	1 pcs		6/7/18	0.00	1.00	Small Fab-9		18-06-12
120	QC	1 pcs		6/7/18	0.00	0.00	QC4		38
125	DC	1 pcs		6/7/18	0.00	0.00	DC		9-89
130	Packaging	1 pcs		6/7/18	0.00	0.00	Packaging3-1		21
140	QC21-FG	1 Ea		6/7/18	0.00	0.00	QC21		18-06-13

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7402

130 - Identify and pack for shipping as per PPP 648.4702

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5058750
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	5038399
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	5064516
600.1313	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	5029483
AN4-16A	Bolt	3 Ea (3 ea)	90-Start up Operation	5068654
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	5057170
C2-3-1	Bearing DU	2 pcs (2 ea)	90-Start up Operation	5068886
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	90-Start up Operation	5056845
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	5050472
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	90-Start up Operation	5058758
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	5079664
C3-10-2	Lock Spring	1 Ea (1 ea)	90-Start up Operation	5070352
C3-12-1	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	5035073
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	90-Start up Operation	5072853
C3-13-1	Keeper Bushing	2 pcs (2 ea)	90-Start up Operation	5029270
C3-13-5	Spring, Keeper	1 pcs (1 ea)	90-Start up Operation	5029273
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	90-Start up Operation	5079589
C3-3-9	Actuator Spring	1 pcs (1 ea)	90-Start up Operation	5029280
C3-4-1	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	5072098
C3-7-1	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	5029283
C3-7-2	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	5067293
C3-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	90-Start up Operation	5079782

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/12/18 Container No: S080439 Part: 648.4702 Job No: 176644 Serial No/Batch: S080439 Revision: 4 Inspector: _____ Exp Date: _____ Instructions: _____				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																					
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> <tr> <td> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____																																																									

NAS1149F0463P	Washer ✓	8 Ea (8 ea)	90-Start up Operation	3056461
MS21044N4	Nut, Self-Locking ✓	4 Ea (4 ea)	90-Start up Operation	5061119
AN4-17A	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5056003
MS21083N3	Nut ✓	2 Ea (2 ea)	90-Start up Operation	5036469
NAS1149F0332P	Washer ✓	2 Ea (2 ea)	90-Start up Operation	5080297
MS35266-63	Solenoid Cover Screw ✓	1 Ea (1 ea)	90-Start up Operation	5038767
NAS1149F0363P	Washer ✓	1 Ea (1 ea)	90-Start up Operation	5027738
AN6-15A	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5026054
MS21083N6	Nut ✓	1 Ea (1 ea)	90-Start up Operation	5036359
NAS1149F0632P	Washer ✓	2 Ea (2 ea)	90-Start up Operation	5048297-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	163	0
	188-FSCS-832-5/8	4	136	0
	600.1309-A	1	0	0
	600.1313	1	0	0
	AN4-16A	3	270	0
	AN4-17A	1	337	0
	AN6-15A	1	51	0
	C2-14-2	2	218	0
	C2-3-1	2	48	0
	C2-3-2-1	2	66	0
	C2-3-3-1	1	17	0
	C2-3-5	2	73	0
	C2-3-8	2	72	0
	C3-10-2	1	26	0
	C3-12-1	2	14	0
	C3-12-6	2	77	0
	C3-13-1	2	50	0
	C3-13-5	1	0	0
	C3-3-4-1	4	146	0
	C3-3-9	1	0	0
	C3-4-1	2	6	0
	C3-7-1	1	1	0
	C3-7-2	2	16	0
	C3-8-4	1	17	0
	MS21044N4	4	96	0
	MS21083N3	2	49	0
	MS21083N6	1	64	0
	MS35266-63	1	75	0
	NAS1149F0332P	2	1,841	0
	NAS1149F0363P	1	646	0
	NAS1149F0463P	8	818	0
	NAS1149F0632P	2	599	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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